

Work Order ID 102076

Thursday, May 23, 2013 1:17:45 PM

102076

Page 1

Item ID: D4703-043

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Lock Pin Base

Stop ***NS2***

Start Date: 5/23/2013 Start Qty: 12.00

12

Cust Item ID:

Required Date: 6/6/2013 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MWF

Date: 13-5-23

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4703	A

100 Cut blanks as per folio

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK AT 2.6"

35 13-05-20 (x12)

110

0.00

110

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER DWG & FOLIO FB132

FOLIO REV: A

DWG REV: A

PD 13/06/02

12 0

DEBURR

Work Order ID 102076***102076***

Page 2

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

PD 13/06/02

12 0

130 QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

B.A 13/06/02

12 0

DAS
08
8-89

132 0.00

132

Outsource4

Memo

0.00

Outsource process - Anodize

CZ 13/06/03 12

P/O: 20010

102076

Page 3

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 5/23/2013 **Start Qty:** 12.00 ***12***

Cust Item ID:

Required Date: 6/6/2013 **Req'd Qty:** 12.00 ***12***

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

134

Receive & Inspect for Damage & Mat'l Certs

0.00

134

Packaging

Memo

0.00

Packaging

136

QC3- Inspect Part Finish

0.00

136

QC

Memo

0.00

Quality Control

137

0.00

137

Small Fab

Memo

0.00

Small Fab

INSERT HELICOIL

Picklist Print

Thursday, May 23, 2013 1:17:45 PM

Page 1
T

Work Order ID: 102076
Parent Item: D4703-043
Parent Item Name: Lock Pin Base

Start Date: 5/23/2013 Required Date: 6/6/2013
Start Qty: 12.00 Required Qty: 12.00

Comments: IPP REV:A NEW ISSUE 12-09-12 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X01.000 6061-T6 Bar .750 x 1.00		Purchased	No				f	26.7600		2.7789474			
				<u>Location</u>				<u>Loc Qty</u>					
				MAT049				26.76					
				112567				26.76					
MS21209-F415 Heli-Coil		Purchased	No				Each	57.0000		12			
				<u>Location</u>				<u>Loc Qty</u>					
				ST319				57					
				123023				57					

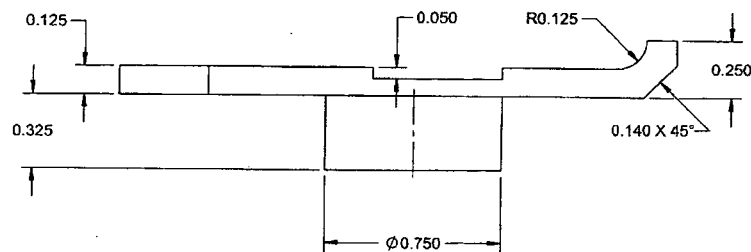
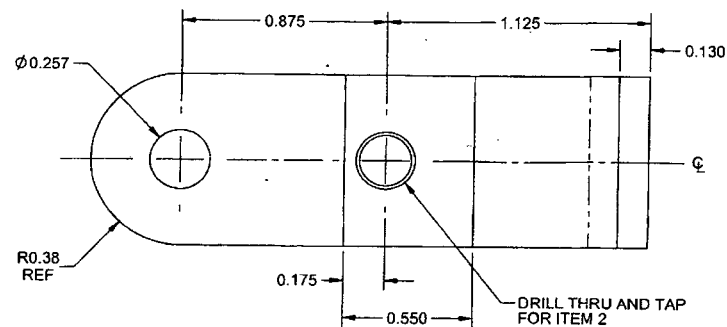
21 13-05-30

2.7

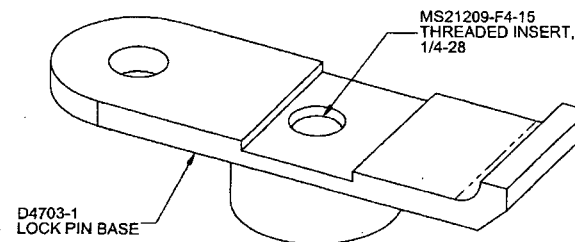
FF 13-06-10

12

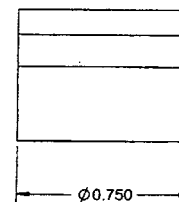
ITEM	QTY.	P/N	DESCRIPTION
	X	D4703-043	LOCK PIN BASE
1	1	D4703-1	LOCK PIN BASE
2	1	MS21209-F4-15	THREADED INSERT, 1/4-28



D4703-1 LOCK PIN BASE



D4703-043 LOCK PIN BASE



RELEASE
2012-10-12

NOTES:

- 1) MATERIAL: 6061-T6/T651 PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221
REF. DART SPEC. M6061T6B
- 2) FINISH: BLACK ANODIZE PER MIL-8625F, TYPE III, CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

DESIGN	RP	DART AEROSPACE USA, INC.	
DRAWN	RP	KENT, WA	
CHECKED	A.P.	DRAWING NO.	REV. A
MFG. APPR.	[Signature]	D4703	SHEET 2 OF 2
APPROVED	[Signature]	TITLE	SCALE
DE APPR.	[Signature]	LOCK PIN ASSY	NTS
DATE	12.09.19	<small>COPYRIGHT © 2012 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

DART AEROSPACE LTD		Work Order:	102076
Description: LOCK PIN Assy		Part Number:	D4703-1
Inspection Dwg: D4703 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.750	± .010	.750	✓		VERN	PHD-12
.125	± .010	.125	✓		"	"
.050	± .010	.050	✓		Mic	PHD-09
R.125	± .010	.125	✓		Rad. G.	
.250	± .010	.250	✓		VERN	PHD-12
.140 x 45°	± .010	.130	✓		"	"
.325	± .010	.325	✓		"	"
Ø.257	+ .006 - .001	.257	✓		"	"
.875	± .010	.874	✓		"	"
1.125	± .010	1.123	✓		"	"
.130	± .010	.135	✓		"	"
.550	± .010	.540	✓		"	"
.175	± .010	.170	✓		"	"

Measured by: PD	Audited by: B.A. DAS	Preliminary Approval:
Date: 13/06/02	Date: 13/06/02 ⁰⁸ ₉₋₈₉	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada

Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 62433

Date: 06-Jun-13

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
1 lot	Part: ASST 10 PCS 646.3310 10 PCS 646.3312 10 PCS 646.3313 10 PCS 646.3610 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 PRIME MIL-P-23377J TYPE I CLASS N Job: 20130348	Rev: 	



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 62433

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DART AEROSPACE LTD
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Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms

Ship Via

Quantity

Description

A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.

ISO 9001 : 2008 REGISTERED
ATG SALES-2010 TERMS APPLY

DATE: 6/6/13

CERTIFIED SIGNATURE: 

RECEIVER SIGNATURE: _____



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO20070**

Purchase Order Date 6/3/2013

PO Print Date 6/6/2013

Page Number 3 of 3

From :

VC-ATG001

T.G. INDUSTRIES INC.
31 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Contact Name

Vendor Phone

Vendor Fax

Vendor Account Nbr

613-446-4544

613-446-4556

Buyer

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

Destination-Collect

5

102076

D4703-043 LOCK PIN
BASE

6/7/2013

Yes

12.00 FedEx PI collect

\$5.2261

\$62.71

Special Inst:

ANODIZE PER MIL-A-8625F TYPE I OR
IB OR IC
OR II OR IIB CLASS 2 COLOR: BLACK

PO Total:

\$371.05

Change Nbr:

2

Change Date: 6/6/2013

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required - YES NO